



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2661-2**Job Sheet 187091****Part No:** D2661-2**Job Qty:** 4 pcs**Part Name:** Saddle, RH, Fwd, Aft, Out**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 11/27/18**Job Tracking No:****Due Date:** 12/19/18**Created By:** Jesse White**Type:** SOLD**Description:**

Note: DWG REV E IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP REV:D REDESIGN
PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	4 pcs	12/19/18		0.00	6.56	HAAS - 1		SBL 18/10/18
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	Conventional Mill - 1 - B4B	4 pcs	12/19/18		0.00	0.26	Conventional Mill - 1 - B4B		SBL 18/12/18
							Conventional Mill - 2 - B4B		
120	QC 2	4 pcs	12/19/18		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 16		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																							
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Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 12/08/18 Container No: S135822 Part: D2661 - 2 Job No: 187091 Serial No/Batch: S135822 Revision: Inspector: Exp Date: Instructions: Various STC's				PAINT CATEGORY				Lead hand / Supervisor Approval Verification																																							
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OTHER : _____																																															

				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 54	
				QC 2 - 56	
				QC 2 - 57	SBZ 18/12/09
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
130 QC 8	4 pcs	12/19/18	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 16	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	anne 18/12/11
				QC 8 - 58	
				QC 8 - 8	
QC 8 - 9					
QC 8 - 68					
140 Handfinish - 1-1 Chemical-B4B	4 pcs	12/19/18	0.00 0.11	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	D.R 18/12/12
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
					Plex 11/27/18 1:16 PM dart.white.jesse

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS					
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
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NCR No. _____		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
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Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
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Past Expiry Date ☐	Manufacturing Process ☐						
Misidentified ☐	Past Due ☐	OTHER :					

				Handfinish - 1 - 22 - B4B	
150	Powdercoat - 1 White GI(A)- B4B	4 pcs	12/19/18	0.00 0.15	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
160	QC 3	4 pcs	12/19/18	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 16
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 26
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 38
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 6
					QC 3 - 68
					QC 3 - 9
170	Packaging 3-1 - Stock - B4B	4 pcs	12/19/18	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
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					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
180	QC 21 - SA	4 pcs	12/19/18	0.00 0.00	QC 21 - SA - 16

BL 18-12-17

DAS 9 18-12-19

9-89

5401

DAS 9-89 DEC 20 2018

DAS 21 9-89 DEC 20 2018

Part Op 100 - (HAAS CNC Vertical Machine), Program part number and batch number MACHINE AS PER DWG AND FOLIO
 Descriptions: FB071 FOLIO REV: _____ DWG REV: _____

110 - (Manufacture as per dwg), Machine Keyway and inspect per attached dimension sheet

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

140 - Chemical Conversion Coat per QSI005 4.1

150 - White Gloss (Ref 4.3.5.1) per QSI005 4.3-Alum START TIME: 1:50 OVEN TEMPERATURE: 320°

FINISH TIME: 2:00 - 11/38951

160 - QC3- Inspect Part Finish

170 - Identify as per dwg & Stock Location:

180 - QC21- Final Inspection - Work Order Release

DQA: _____ Date: _____



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OTHER :																																																															

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6101-003	Saddle Billet, 7075	4 Ea (1 ea)	100-HAAS 4 Axis	S0386542 S135821
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-003	4	39	0
Part Specifications				
Specifications could not be found.				

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DART AEROSPACE LTD				Work Order:	
Description: 206 Saddle, Outboard, Right side				Part Number: D2661-2	
Inspection Dwg: D2661 Rev: E DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.616	3.616	3.616	3.616	
B	0.256	0.263		.257	.257	.257	.257	
C	0.315	0.322		.316	.316	.316	.316	
D	2.495	2.505		2.500	2.500	2.500	2.500	
E	1.674	1.684		1.679	1.679	1.679	1.679	
F	1.357	1.367		1.362	1.362	1.362	1.362	
G	0.100	0.140		.121	.120	.120	.120	
H	0.210	0.230		.225	.225	.224	.223	
I	0.615	0.685		.680	.680	.680	.680	
J	2.470	2.510		2.495	2.495	2.495	2.495	
K	1.313	1.343		1.324	1.323	1.323	1.323	
L	0.178	0.198		.188	.188	.188	.188	
M	0.470	0.530		.500	.500	.500	.500	
N	1.125	1.145		1.136	1.136	1.136	1.136	
O	0.100	0.180		.130	.123	.132	.130	
P	0.100	0.140		.135	.135	.135	.135	
Q	0.240	0.260		.251	.250	.250	.250	
R	0.677	0.697		.688	.688	.687	.688	
S	0.100	0.140		.130	.125	.125	.125	
T	1.565	1.585		1.576	1.576	1.576	1.576	
U	0.540	0.560		.549	.550	.550	.550	
V	0.912	0.932		.920	.919	.920	.919	
W	0.787	0.807		.796	.795	.795	.795	
X	5.990	6.010		5.998	5.997	5.996	5.997	
Y	4.995	5.005		5.000	5.000	5.000	5.000	
Z	0.490	0.510		.500	.500	.500	.500	
AA	0.312	0.319		.313	.313	.313	.313	
AB	0.990	1.010		1.000	1.002	1.002	1.001	
AC	1.245	1.255		1.250	1.250	1.250	1.250	
AD	0.490	0.510		.501	.501	.502	.502	
AE	3.745	3.755		3.750	3.750	3.750	3.750	
AF	0.235	0.240		.239	.239	.239	.239	
AG	0.510	0.515		.510	.510	.510	.510	
AH	0.100	0.120		.120	.120	.120	.120	

DAS Accept/Reject

Measured by: 57	Date: 18/12/09
Audited by: 9-89 MML	Date: 18/12/11
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
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